

# Work Order ID 71382

Thursday, June 30, 2011 11:39:49 AM



Page 1

Item ID: D3562-041

Accept



Setup Start



Revision ID:

Item Name: Step Assembly, LH

Stop



Start Date: 6/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*HP*

Date:

*11-06-30*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3562

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562  
2-Deburr and bevel ends for welding

*11/4 Ae 11.07.06*

*3 0*

110

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

*QC 11.07.06*

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

*11.07.06 3 0*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 71382

Thursday, June 30, 2011 11:39:49 AM



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|                |                   |            |      |               |       |  |
|----------------|-------------------|------------|------|---------------|-------|--|
| Item ID:       | D3562-041         | Accept     |      | Setup         | Start |  |
| Revision ID:   |                   |            |      |               | Stop  |  |
| Item Name:     | Step Assembly, LH |            |      |               |       |  |
| Start Date:    | 6/30/2011         | Start Qty: | 4.00 | Cust Item ID: |       |  |
| Required Date: | 7/5/2011          | Req'd Qty: | 4.00 | Customer:     |       |  |
| Reference:     |                   |            |      |               |       |  |

|            |               |       |            |       |     |       |  |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool #      | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|-------------|--------------|---------------|---------------|------------------|----------------|
| 130<br>                        | QC3- Inspect Part Finish  | 0.00                 |         |             |              | <u>(2)</u>    |               |                  |                |
| QC<br>Quality Control          | Memo  | 0.00                 |         | SB 11/07/07 |              |               |               |                  |                |
| 140<br>                        | Small Fab   | 0.00                 |         |             |              | <u>3</u>      |               |                  |                |
| Small Fab<br>Small Fab         | Memo  | 0.00                 |         | 11-07-07    |              |               |               |                  |                |
|                                | 1- Transfer drill Rivet holes as per dwg D3562.<br>2-Touch-up rivet holes with alodine as per dwg d3562<br>3-Rivet legs using Magnabond as per dwg D3562.<br>*****Ensure to wipe off any excess magnobond *****<br>A/R Magnabond 6398 Batch: <u>M117870</u><br><u>M117870</u> |                      |         |             |              |               |               |                  |                |
| 150<br>                        | QC5- Inspect part completeness to step on W/O   | 0.00                 |         |             |              | <u>(83)</u>   |               |                  |                |
| QC<br>Quality Control          | Memo  | 0.00                 |         | 8/11/07     |              |               |               |                  |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 71382**

Thursday, June 30, 2011 11:39:49 AM



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Item ID: D3562-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, LH

Start Date: 6/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Large Fab

Large Fab

0.00

Memo

0.00

11-07-08

3

Ø

Large Fab

1-Weld end caps as per Dwg d3562 &amp; QSI 004. Inspect for foreign objects as per QSI 024.

A/RAluminum Rod M114703

2-Grind end cap welds flush as per Dwg D3562

11-07-11

3

Ø

170



QC

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/11/15

Quality Control

180



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/15

73

44

Quality Control

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 71382

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|                |                   |            |      |               |       |  |
|----------------|-------------------|------------|------|---------------|-------|--|
| Item ID:       | D3562-041         | Accept     |      | Setup         | Start |  |
| Revision ID:   |                   |            |      |               | Stop  |  |
| Item Name:     | Step Assembly, LH |            |      |               |       |  |
| Start Date:    | 6/30/2011         | Start Qty: | 4.00 | Cust Item ID: |       |  |
| Required Date: | 7/5/2011          | Req'd Qty: | 4.00 | Customer:     |       |  |
| Reference:     |                   |            |      |               |       |  |

|            |               |       |            |       |     |       |  |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID          | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190<br><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo  | 0.00<br><br>0.00     |         |        |              | 3.            | BL            | 11-7-20          |                |
| 200<br><br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br>1117745.<br>Memo<br>START TIME: 11:30<br>OVEN TEMPERATURE: 320<br>FINISH TIME: | 0.00<br><br>0.00     |         |        |              | 3             | BL            | 11-7-20          |                |
| 210<br><br>HandFinish<br>Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch 1117863<br>Memo  | 0.00<br><br>0.00     |         |        |              | 3             | BL            | 11-7-20          |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**Work Order ID 71382**

Thursday, June 30, 2011 11:39:49 AM



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Item ID: D3562-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, LH

Start Date: 6/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 11/07/21 (3)

230

Identify as per dwg &amp; Stock Location GA

0.00



Packaging

Memo

0.00

Packaging

w/o 70592

EP 11/07/21 (3)

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/21 df  
mf 11-07-21

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 30, 2011 11:39:56 AM

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Work Order ID: 71382

Parent Item: D3562-041

Parent Item Name: Step Assembly, LH



Start Date: 6/30/2011

Required Date: 7/5/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM  
 IPP rev B ECN 987 07.10.09 EC verified by: DD  
 IPP Rev:C ECN1048 07-12-18 DD verified by:ec  
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|                              |  |              |    |  |  |     |      |          |   |  |  |  |  |
|------------------------------|--|--------------|----|--|--|-----|------|----------|---|--|--|--|--|
| D2622-120C<br>Step Extrusion |  | Manufactured | No |  |  | 100 | Each | 145.7000 | 1 |  |  |  |  |
|------------------------------|--|--------------|----|--|--|-----|------|----------|---|--|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL     | 132     |          |
| 64409    | 6       |          |
| 68293    | 126     |          |
| WA       | 13.7    |          |
| 46910    | 2       |          |
| 66970    | 11.7    |          |

11-07-06

WA 68293 (X3)

|                         |  |              |    |  |  |     |      |         |   |  |  |  |  |
|-------------------------|--|--------------|----|--|--|-----|------|---------|---|--|--|--|--|
| D2734<br>Step End Plate |  | Manufactured | No |  |  | 140 | Each | 83.0000 | 2 |  |  |  |  |
|-------------------------|--|--------------|----|--|--|-----|------|---------|---|--|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA       | 83      |          |
| 69537    | 8       |          |
| 70701    | 75      |          |

11-07-08

|                           |  |              |    |  |  |     |      |        |   |  |  |  |  |
|---------------------------|--|--------------|----|--|--|-----|------|--------|---|--|--|--|--|
| D3560-041<br>Arm Weldment |  | Manufactured | No |  |  | 140 | Each | 4.0000 | 1 |  |  |  |  |
|---------------------------|--|--------------|----|--|--|-----|------|--------|---|--|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA       | 4       |          |
| 69615    | 4       |          |

11-07-07

3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 30, 2011 11:39:56 AM

Page 2

Work Order ID: 71382

Parent Item: D3562-041

Parent Item Name: Step Assembly, LH

Start Date: 6/30/2011

Required Date: 7/5/2011

Start Qty: 4.00

Required Qty: 4.00

D3560-043

Manufactured No

140 Each

3.0000

1

4



Arm Weldment



11.07.07

## Location

## Loc Qty

## Loc Code

WA

3

69613

3

3

MS20600-AD4W5

Purchased

No

160

Each

623.0000

32

128



Blind Rivet



11.07.07

## Location

## Loc Qty

## Loc Code

ST321

617

114382

173

117505

200

117739

200

117885

44

WA018

6

111477

6

88

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

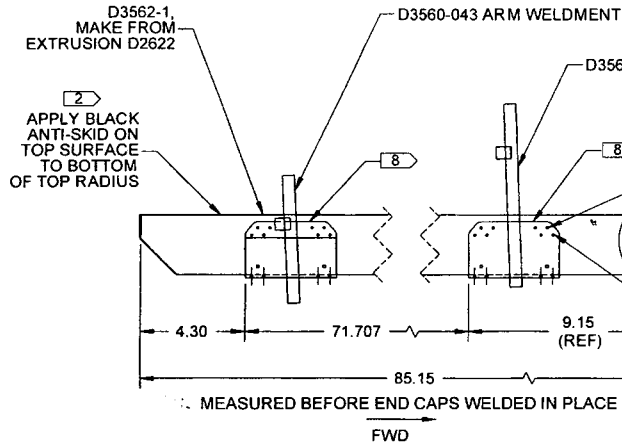
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

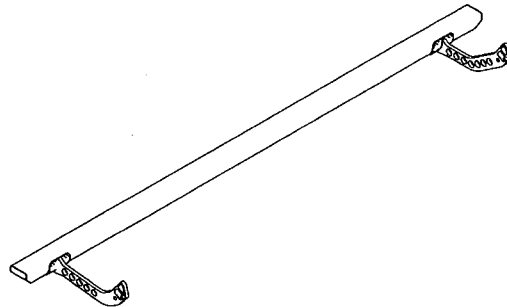
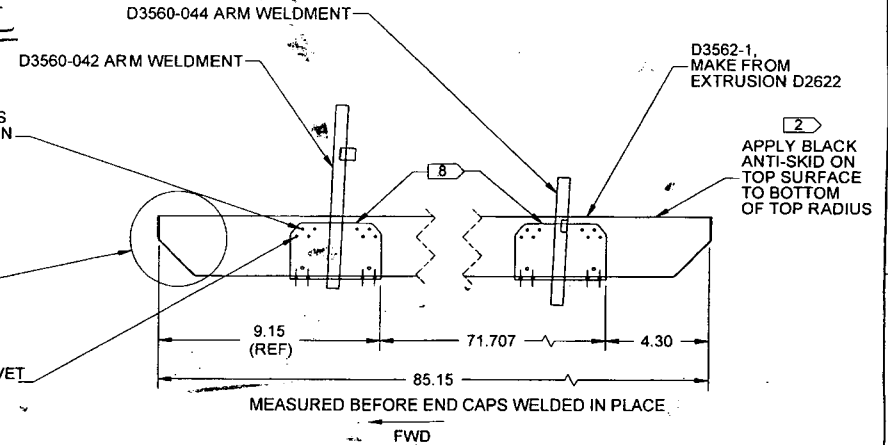
WITHOUT NOTICE  
WORK ORDER  
NO. 71382



TRANSFER DRILL #30  
DEBURR & TOUCH UP HOLES  
WITH CHEMICAL CONVERSION  
COAT BEFORE RIVETING  
(32 PLACES PER STEP)

REFER TO STEP  
END DETAIL

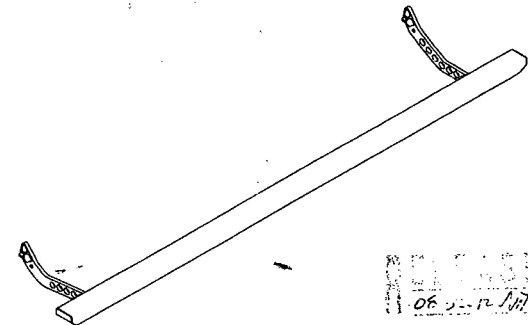
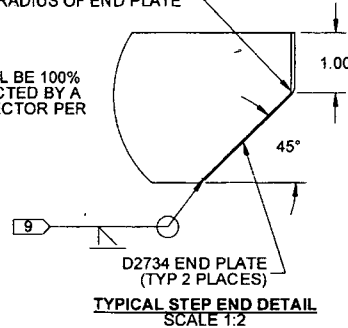
INSTALL MS20600AD4W5 RIVET  
(32 PLACES PER STEP)



**D3562-041 LH STEP ASSEMBLY**

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100%  
VISUALLY INSPECTED BY A  
QUALIFIED INSPECTOR PER  
PART QSI 004



**D3562-042 RH STEP ASSEMBLY**

- NOTES:  
1) MATERIAL: N/A  
2) FINISH:  
i) CHEMICAL CONVERSION COAT STEP EXTRUSION  
PER DART QSI 005 4.1 BEFORE ASSEMBLY  
ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR  
GREY SANDTEX (4.3.5.6) OR  
BLACK SANDTEX (4.3.5.7) OR  
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 8.79 lbs  
8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN  
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH  
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.  
9) WELDING: PER DART QSI 004

| QTY<br>-041 | QTY<br>-042 | P/N          | DESCRIPTION      |
|-------------|-------------|--------------|------------------|
| X           |             | D3562-041    | LH STEP ASSEMBLY |
|             | X           | D3562-042    | RH STEP ASSEMBLY |
| 1           |             | D3560-041    | ARM WELDMENT     |
| 1           | 1           | D3560-042    | ARM WELDMENT     |
| 1           |             | D3560-043    | ARM WELDMENT     |
|             | 1           | D3560-044    | ARM WELDMENT     |
| 32          | 32          | MS20600AD4W5 | RIVET            |
| 2           | 2           | D2734        | END PLATE        |

|            |  |    |          |
|------------|--|----|----------|
| E          | ADD QTY (2) TO D2734 END PLATE ON D3562-042        | PH | 08.01.11 |
| D          | REMOVE D2808 SPACER NOTE; REDRAWN IN<br>SOLIDWORKS | DC | 07.11.16 |
| C          | NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS          | CP | 07.06.19 |
| B          | ARMS NOW RIVETED TO STEP                           | CP | 07.01.15 |
| A          | NEW ISSUE  | CP | 06.09.26 |
| REV.       | DESCRIPTION  | BY | DATE     |
| DESIGN     | JP   |    |          |
| DRAWN      | SE   |    |          |
| CHECKED    | LE   |    |          |
| MFG. APPR. |  |    |          |
| APPROVED   |  |    |          |
| DE APPR.   |  |    |          |
| DATE       | 08.01.11   |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3562** REV. E  
TITLE **STEP ASSEMBLY** SCALE 1:5

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries